

Push

Work Order ID 87532

July-17-12 2:33:41 PM

87532

Item ID: D2438

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Clamp

Start Date: 7/17/12

Start Qty: 60.00

60

Cust Item ID:

Required Date: 7/20/12

Req'd Qty: 60.00

60

Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2438	Rev C								
100	PURCHASING	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut as per dwg D2438								
304.063	prog rev: <i>C</i>								
	dwg rev: <i>C</i>								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control	Ensure Material Release Note is attached								
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control	(6.786" center to center)								

60 0 Jm 12-7-12

60 0 Jm 12-7-12

Smb 12-7-18

DAS 16

17/07/18

counts (60)

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Item ID: D2438 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clamp
 Start Date: 7/17/12 Start Qty: 60.00 ***60*** Cust Item ID:
 Required Date: 7/20/12 Req'd Qty: 60.00 ***60*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab	Small Fab	0.00				60			<i>S</i> 12/18/18
Small Fab	Memo 1- Use DT9713 clamp holder to hold clamp in place when forming 2- Bend as per dwg usind DT9709	0.00							
140 *140* QC	QC5- Inspect part completeness to step on W/O	0.00							<i>counts</i> <i>16</i> 12/18/18
Quality Control	Memo	0.00							
150 *150* Packaging	Identify as per dwg & Stock Location: <i>SS</i>	0.00							<i>12/17/19</i> <i>60</i>
Packaging	Memo <i>Y56</i>	0.00							

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Start Qty: 60.00

60

Cust Item ID:

Required Date: 7/20/12

Req'd Qty: 60.00

60

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/17/20
MF
12-07-17

Picklist Print

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Work Order ID: 87532

Parent Item: D2438

Parent Item Name: Clamp

Start Date: 7/17/12

Required Date: 7/20/12

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP: E05.06.28Bending removedKJ/JLM

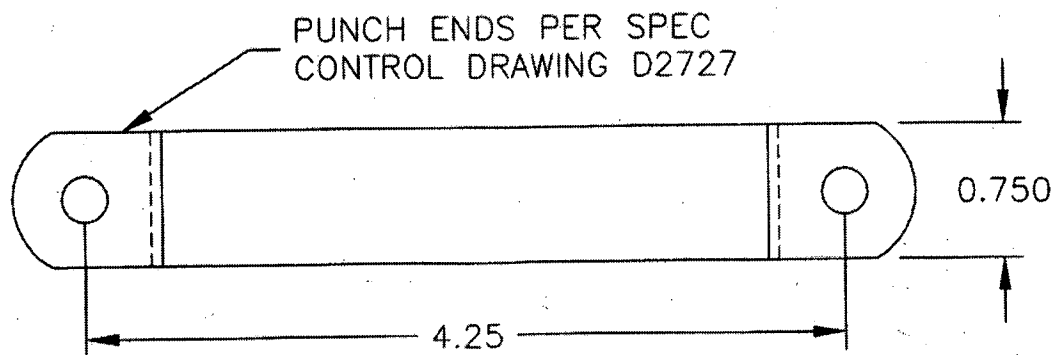
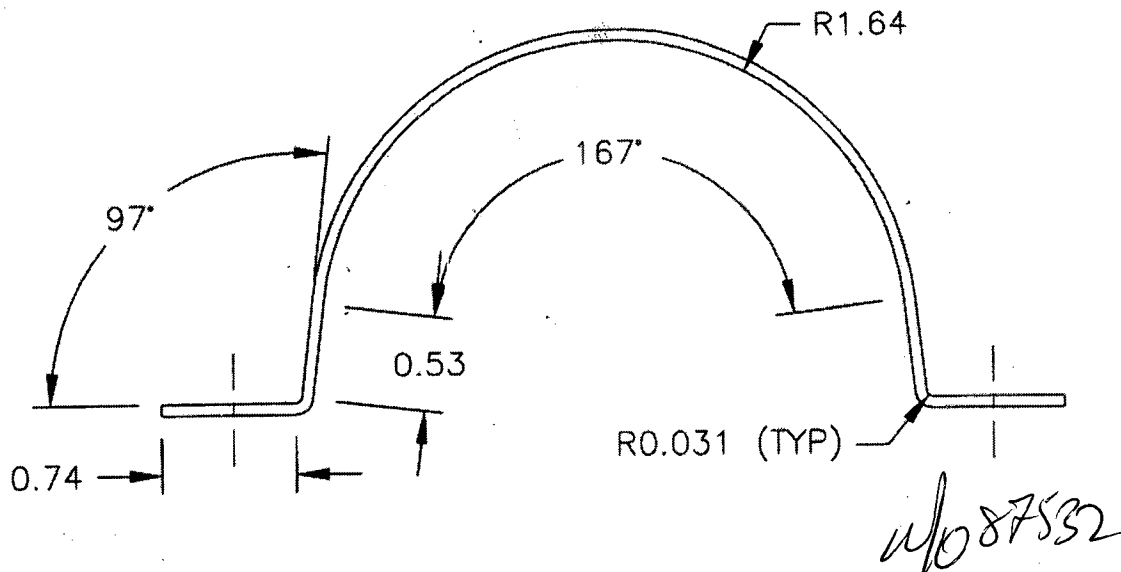
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	289.1400	0.04	2526318 26			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT020		289.14							
				122245		129.14				122245			
				122321		160							

DART



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MD</i>	APPROVED <i>KE</i>	DRAWING NO. D2438	REV. C
DATE 98.05.12		TITLE CLAMP	SHEET 1 OF 1 SCALE 1:1
A	96.01.24	NEW ISSUE	
B	96.05.13	CHANGE LENGTH	
C	98.05.12	R1.64 WAS R1.438, CHANGE GEOMETRY	

RELEASED
98.06.17 KE



FLAT LENGTH: 7.586 END-END
6.786 HOLE-HOLE

MATERIAL: AISI 304/316 SS 0.063 THICK

MINIMUM REQUIREMENT IS ANNEALED CONDITION

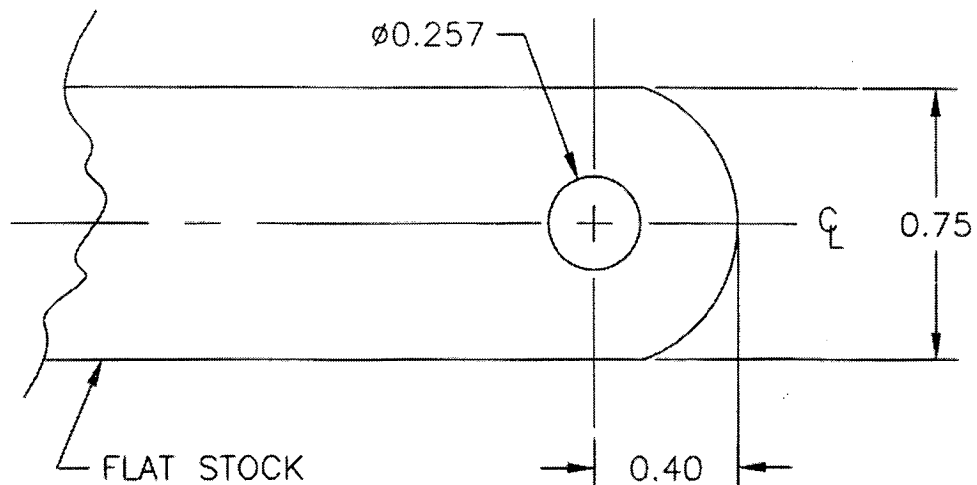
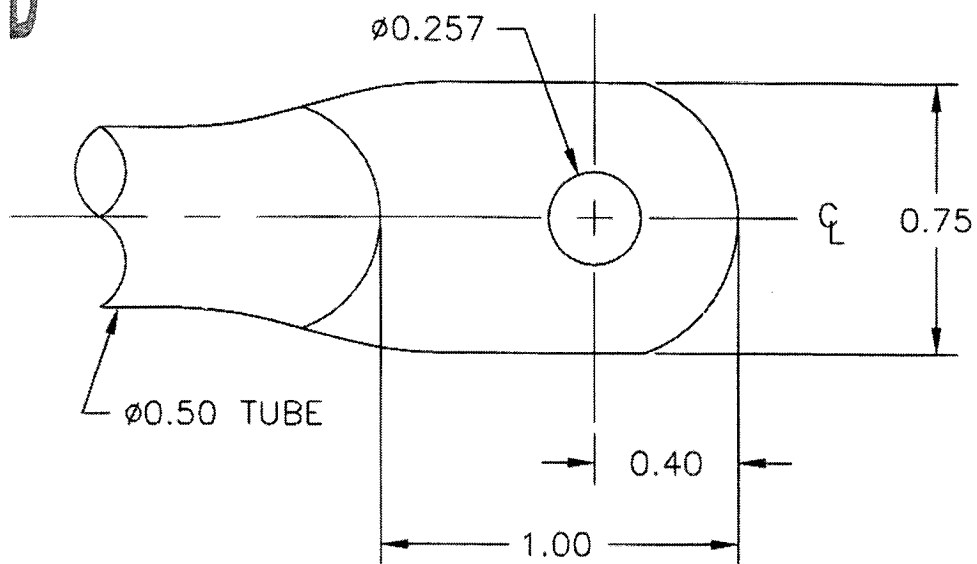
00.06.06
CP 00.06.07



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2727	REV. A SHEET 1 OF 1
DATE 97.11.24		TITLE PUNCH DT8012 SPEC CONTROL	SCALE 2:1
A	97.11.24	NEW ISSUE	
A1	#10 01.12.20	ADD TOLERANCE NOTE	

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8012

RELEASED
94/03/06 KE



NOTE: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

